

Work Order ID 68405

Tuesday, April 12, 2011 3:38:11 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4369-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00

Customer:

Reference:



Approvals:

Process Plan:

H

Date: 4/10/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4369

PA1

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 76.25"

74.75

[Signature]

11/04/27

[Stamp]

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio EB044 & dwg D4369,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual Mill

[Signature]

11/04/28

[Stamp]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/04/28

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/4/28

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/04/28

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00 - inspect to spec



QC

Memo

0.00

Quality Control

Done only
8 w/loc/25

160

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

FL 11-5-3 (X)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11-05-03 AUTH [Signature]

RELEASED _____ DATE _____

RD2382 MF 11-05-03

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Picklist Print

Tuesday, April 12, 2011 3:38:18 PM

Page 1

Work Order ID: 68405



Parent Item: D4369-1



Parent Item Name: Bar

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	269.5000	6.354	6.688421			



304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

78

116148

78

MAT050

191.5

117176

191.5

6.4 ~~7.0~~ 11/04/28

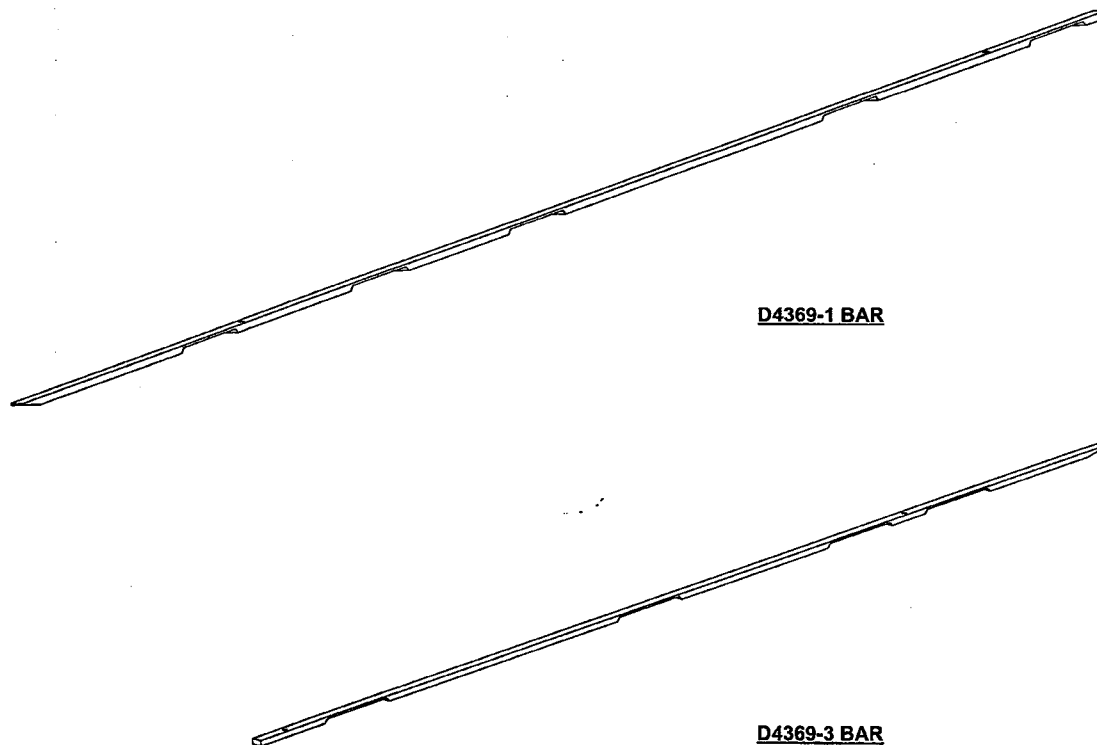
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D4369-1 BAR

D4369-3 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68405

Pl 11-04-12

**PRELIMINARY
ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>GP</i>	D4369	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.</small>	

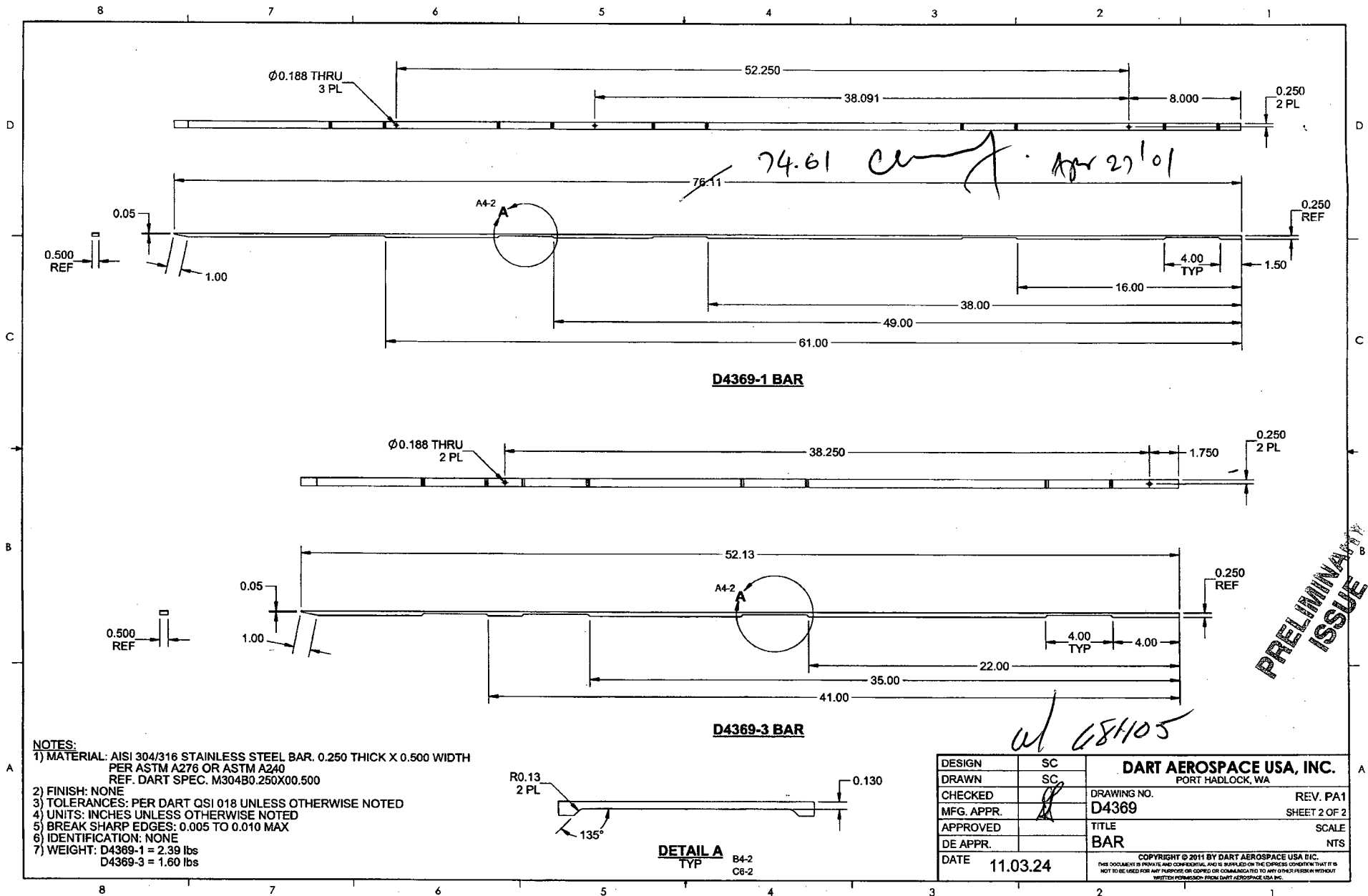
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